

# Work Order ID 66178

Monday, February 07, 2011 11:40:36 AM



Page 1

Item ID: D3247-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: WKF

Date: 11-02-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3247	Rev A

100



Waterjet

FLOW CNC Waterjet

2024 . 063

Memo

0.00

B 11-2-17

(6)

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110



QC

Memo

0.00

B 11-2-17

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\*NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

M 11 01 17 (6)

130



Brake NC

Brake NC

Bend as per dwg

0.00

SB 11/02/17

(6)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

SW/02/17

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Setup Start



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Item Name: Angle

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Start Date: 2/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



HandFinish

Hand Finishing

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

6 6 11-02-22

155



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 112588

Memo

0.00

START TIME: 8:15.  
OVEN TEMP: 320.  
FINISH TIME: 3:45.

6 bl 11-2-23.

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

6 b 11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 66178**

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Page 4

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Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

170

Operation  
DescriptionIdentify as per dwg & Stock Location: 180ASet Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Packaging

Memo

0.00

11/2/24 628

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/25 HD

MF  
11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Monday, February 07, 2011 11:40:34 AM

Page 1

Work Order ID: 66178



Parent Item: D3247-1



Parent Item Name: Angle

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3247-1 no longer made in-house  
10.12.06 NOW MADE IN HOUSE DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	31.9270	0.2347	0.988211		18 11-2-17	

2024-T3 .063 sheet



Location	Loc Qty	Loc Code
MAT22	31.927	
114351	31.927	114351

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66178
Description: Angle	Part Number:	D3247-1
Inspection Dwg: D3247	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>VB</u>	Audited by:	<u>MM</u>	Prototype Approval:	N/A
Date:	11-2-17	Date:	11-02-17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	SJL

W/O:		WORK ORDER CHANGES					
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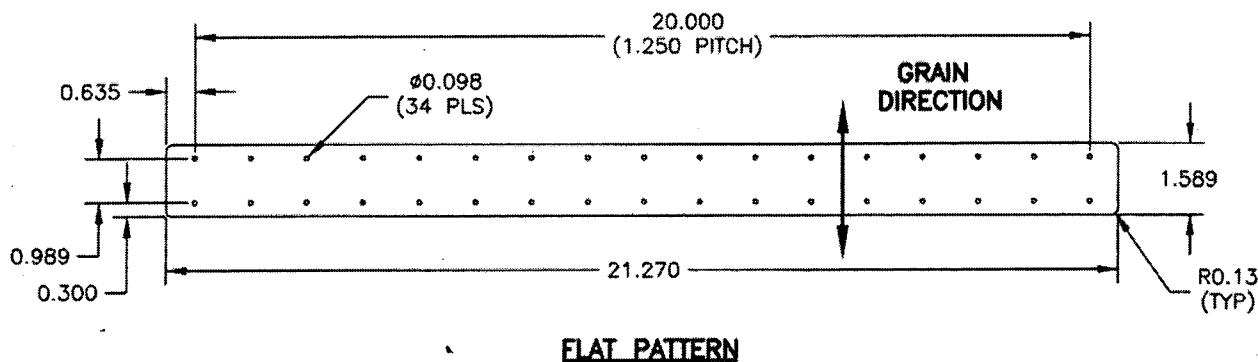
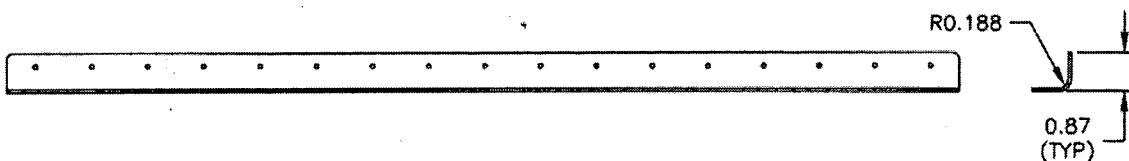
NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AP	APPROVED F	DRAWING NO. D3247	REV. A SHEET 1 OF 1
DATE 04.04.06	TITLE ANGLE	SCALE 1:4	
A	04.04.06	NEW ISSUE	

**RELEASED**  
04.04.27 RF

#66178

**FLAT PATTERN****D3247-1 BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O:		WORK ORDER CHANGES					
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